

Work Order ID 151380

Friday, September 23, 2016 2:49:04 PM

151380

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Item ID: D2572 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Saddle, Fwd, In
Start Date: 9/22/2016 Start Qty: 8.00 *8* Cust Item ID:
Required Date: 10/4/2016 Req'd Qty: 8.00 *8* Customer:
Reference:

Approvals: Process Plan: DAS Date: SEP 26 2016 Tooling: _____ Date: _____ Run Start ***NR1***
QC: 21 Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***
9-89

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
D2572	F

100

0.02

100

HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.51

HAAS CNC vertical machine #1

Program Batch No. 151380Double check by: marc

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets

2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets

3-Machine Step No 3 per Folio FA051 and insp

8✓DAS
44
9-89
14
9-89
DAS
20
9-89

16-10-23

16-10-25

16-10-27

110

0.00

110

CONVENTIONAL MILLING MACHINE

Mill Conv

Memo

0.21

Conventional Milling Machine

Machine keyway as per dwg D2571 & D2572

8✓DAS
44
9-89
20
9-89

16-10-23

16-10-25

16-10-27

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[illegible]

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[illegible]

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Item ID: D2572

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Saddle, Fwd, In

Start Date: 9/22/2016 Start Qty: 8.00

8

Cust Item ID:

Required Date: 10/4/2016 Req'd Qty: 8.00

8

Customer:

Reference:

Run Start

NR1

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop

NR2

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

180

QC21- Final Inspection - Work Order Release

0.00

180

QC

Memo

0.13

Quality Control

21
9-29

NOV 04 2016

11-03

Picklist Print

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Page 1

Work Order ID: 151380

151380

Parent Item: D2572

D2572

Parent Item Name: Saddle, Fwd, In

Start Date: 9/22/2016

Required Date: 10/4/2016

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP: I02.10.02Re-format; Change to Dwg Rev. D & incorporated
D2572KJ

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D6101-005

Manufactured

No

100

Each

37.0000

1

8

DAS

D6101-005

44
9-89

16-10-22

Saddle Billet

Location

Loc Qty

Loc Code

MAT040

17

147755

3

149947

14

MAT041

20

149199

20

8

DART AEROSPACE LTD		Work Order: 157580
Description: Saddle, Fwd Inboard		Part Number: D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.500	.502	.502	.502		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.498	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.567	.567		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.125	.124	.124	.124		
R	0.240	0.260		.253	.253	.253	.252		
S	0.115	0.135		.125	.127	.127	.127		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.239		
W	0.115	0.135		.124	.124	.124	.124		
X	0.307	0.312		.311	.311	.311	.311		
Y	0.760	0.765		.761	.761	.763	.763		
Z	0.352	0.372		.363	.363	.364	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.624	.624	.623		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.251	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.246	.252	.249	.248		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

DAS

Measured by: 44	16-10-24
Date: 9-09	16/10/25

Audited by: D.A	DAS
Date: 16/10/28	08

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	

DART AEROSPACE LTD		Work Order:	157380
Description: Saddle, Fwd Inboard		Part Number:	D2572
Inspection Dwg: D2572 Rev. F		Page 1 of 1	

Inspect dimensions highlighted on inspection sheet drawing D2572 Rev. E and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	15	26	37	48		
A	0.438	0.443		.438	.438	.438	.438		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.496	.496	.497	.496		
G	0.257	0.262		.258	.258	.258	.258		
H	0.375	0.380		.375	.375	.375	.375		
I	0.490	0.510		.500	.500	.497	.498		
J	1.174	1.184		1.179	1.179	1.179	1.179		
K	0.558	0.578		.568	.568	.566	.566		
L	1.174	1.184		1.179	1.179	1.179	1.179		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.135	.135	.135	.135		
Q	0.115	0.135		.125	.125	.124	.124		
R	0.240	0.260		.253	.253	.252	.252		
S	0.115	0.135		.127	.126	.121	.122		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.239	.238	.239		
W	0.115	0.135		.124	.124	.124	.124		
X	0.307	0.312		.308	.309	.311	.308		
Y	0.760	0.765		.762	.762	.762	.762		
Z	0.352	0.372		.363	.363	.363	.363		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.625	.625	.625	.625		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.249	.249		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.135	.135	.135	.135		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.257	.254	.251	.251		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		

Accept/Reject

Measured by:	20
Date:	16/10/26 16-10-27

Audited by:	DAS
Date:	16/10/28 05-05

Rev	Date	Change	Revised by	Approved
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	
F	13.03.07	Dwg Rev updated	KJ	



